

Date: Thursday, 11/15/2007 1:20:20 PM
 Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GAS SPRING
 Job Number : 35751
 Estimate Number : 10336
 P.O. Number :
 This Issue : 11/15/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D2807-041
 First Issue : 11 Type : PURCHASED PARTS Drawing Number : D2807 UNDER REVIEW
 Previous Run : 33941 Drawing Revision : N/A
 Material :
 Due Date : 12/10/2007 Qty: 100 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: D 05.06.21 Removed painting; Changed supplier
 KJ/JLM

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 5053

C20711116 (100)

Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems or LS Technologies

Material release note is required

2.0

SXF6S6050080S6L115N

GAS SPRING



(PE) →

Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 SUPPORT PROP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

7/14/09 (20) 7/12/13 100x 50

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

2003-06

2SP 019

counter
 4100

5.0

D28073

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 200.0000 Each(s)

Pick:

2 D2807-3 Lug Batch:

already on gas street

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2807 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: <u>35751</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>02/04/01</u>	<u>#60</u>	<u>one parts was taken for eng. testing + cannot find *</u>	<u>[Signature]</u>	<u>Scrap - Qty (X1) No Repair used for eng.</u>	<u>N/A</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 35751

Part Number: D2807

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using 818791 crimp jig.

2-Remove lettering and logo with wash and wipe.

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



6.0 Pick A3671-1 Placard.

* And install

Batch: B35964 98

B38205 ②

MF 08-04-02

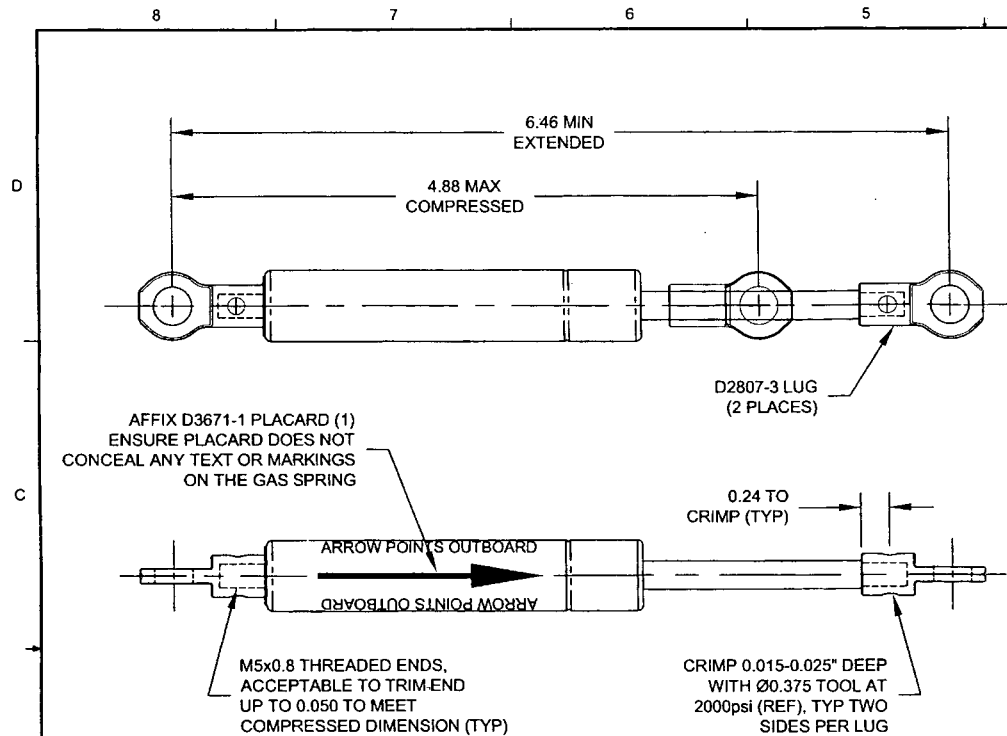
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2807-1 GAS SPRING

- NOTES:**
- 1) MATERIAL: NONE - SEE NOTE #8
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.147 lbs
 - 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS
- POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

D2807-041 GAS SPRING ASSEMBLY

- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.179 lbs

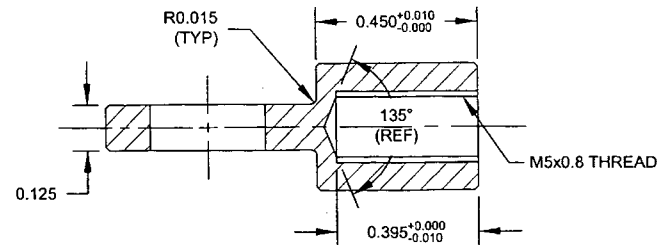
D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-041		
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-1	GAS SPRING
2	D2807-3	LUG
1	D3671-1	PLACARD

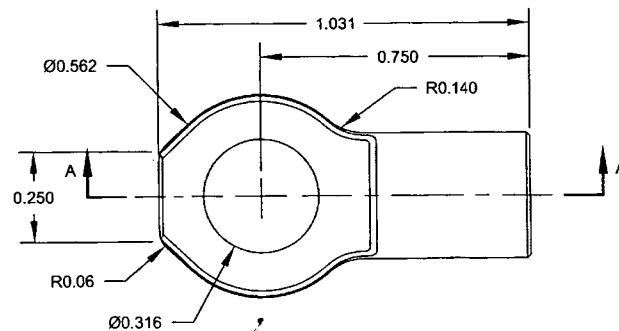
NO. 36751
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 ENGINEERING
 RETURN TO
 SHOP COPY

RELEASED
07-11-06

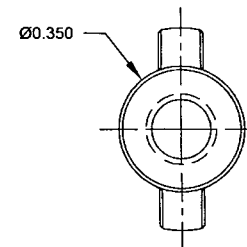
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. D
CHECKED	LS	D2807	SHEET 1 OF 2
MFG. APPR.	MS	TITLE	SCALE
APPROVED	MS	GAS SPRING	1:1
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.09.27		



SECTION A-A



D2807-3 LUG



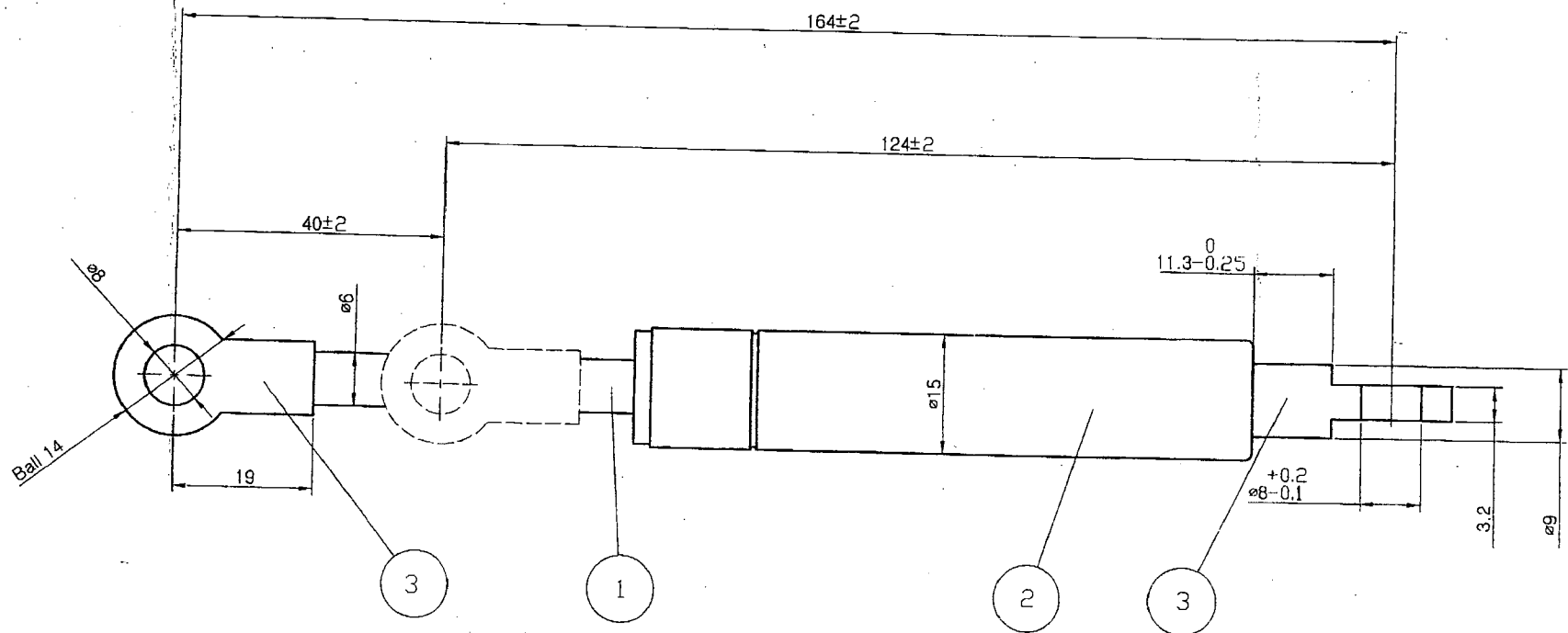
NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 lbs

NO. _____
 WORK ORDER
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

RELEASED
 07.11.06

DESIGN		DART AEROSPACE LTD	
DRAWN	DL	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO. D2807	REV. D
MFG. APPR.		TITLE	SCALE
DE APPR.		GAS SPRING	3:1
DATE	07.09.27	COPYRIGHT © 2000 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Note

1. Force

All force are collected to 20±2C

$$1) F_t = (F_1 + F_2) / 2 = 115N \pm 20N_{\text{Net}}$$

$$2) F_c = (F_3 + F_4) / 2 = 120(\text{REF})$$

$$3) F_r = F_3 - F_4 = \text{Max: } 20N_{\text{Net}}$$

2. Appearance

No Harmful crack and scratch is not allowed.

All leakage is not allowed.

3. Application temperature range: -20-90° c

4. Durability test

After 20,000 cycles at room temperature (-20-90°)

1) Unit must operated normally

2) Change rate of force is no more than 10% of initial value.

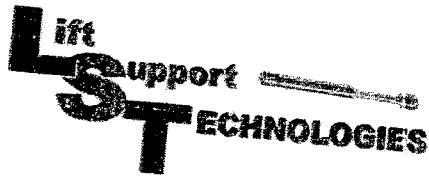
NO	Date	Contents	Check	Desing	Bugil Park	Part Name	Code No	Material
③	2	End Eye						SUS304
②	1	Cylind						SUS304
①	1	Rod						SUS304
NO	Qty	Part Name	Code No	Material				
1		Check						
2		Approval						
3		Company						
4		Model						
5								

Revision Contents

NO	Date	Contents	Check	Desing	Bugil Park	Part Name	Code No	Material
1								
2								
3								
4								
5								

CANADA

6/15-164/50-115N



P.O. Box 25032, Saskatoon, Saskatchewan, Canada S7K 8B7
Ph: (306) 683-5000 Fax: (306) 683-6403
E-mail: info@lsttechnologies.ca
Web: www.lsttechnologies.ca

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

100 Units: D2807 Stainless Steel Gas Spring

Country of Manufacture: Canada

Date of Manufacture : December 11/2007

This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 5053
Invoice # 3988

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr".

Nolan Fehr
Manager

